

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008160**Date Inspected:** 23-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Jiang Xiaobo, Wen Zhong Wan, LCW			Weld Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay10, Lift 3, Skin A, North Tower.

FCAW welding of weld joint NSD1-FASA3-2A/E-2A; located on Bay10, Lift 3, Skin A, North Tower.

Welder is identified as 048627; ZPMC Quality Control Inspector (QC) is identified as Jiang Xiaobo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

WPS-345-FCAW-1G-REPAIR.

Bay10, Lift 3, Skin C, North Tower.

FCAW welding of weld joint NSD1-FCSA3-1B/C-65B; located on Bay10, Lift 3, Skin C, North Tower.

Welder is identified as 040475; ZPMC Quality Control Inspector (QC) is identified as Wen Zhong Wan. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

WPS-B-T-2211-B-U3C-S-2.

Bay11, Lift 3, Skin D, East Tower.

FCAW welding of weld joint ESD1-FDSA3-2B/C-43, 44, 29, 30, 36, 37; located on Bay11, Lift 3, Skin

D, East Tower. Welder is identified as 068864, 068918, 066733, 066695, 044810, 066763; ZPMC Quality Control Inspector (QC) is identified as Li Ming. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2332-TC-P5-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector carried out NDE on following:

Bay 11, West Tower, Lift 3, Skin C.

This QA inspector performs Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as WDS1-FCSA3-2A/C-1A, 2A, 3A.

Bay 11, East Tower, Lift 2, Skin C.

This QA inspector performs Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as BC,CD Corner Diagonal stiffener Plates.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
